

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000013**Date Inspected:** 07-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hung Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Component:** N/A**Bridge No:** 34-0006**Summary of Items Observed:**

Office of Structural Materials Quality Assurance Inspector (QA), David McClary observed welding and quality control functions related to procedure qualification testing at the ZPMC facility in Shanghai, Republic of China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item	Description	WBS	Dwg No.	Status
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1

The QA Inspector observed the machining of the backing bar off of 1G FCAW Max PQR, ID number HP2006103. It appeared the rejectable indication on the film was caused by internal undercut at root. Caltrans Welding Engineer Mr. Jim Merrill informed ZPMC that Caltrans would allow them to proceed with machining and mechanical testing, as any discontinuities that could have been concealed by the root indication would be apparent on the machined samples.



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Summary of Conversations:

ZPMCs Testing Center Director Mr. Liu Liu informed Caltrans that the machining of PQR test specimens would be performed at a different machine shop than that originally audited by Caltrans. Caltrans Welding Engineer Jim Merrill questioned why ZPMC had Caltrans audit the ZPMC machine shop facility if they had intended to use a different facility to perform the machining. Mr. Merrill stated that it had been his understanding from ZPMC that the outside facility would only be cutting samples down in size to allow for machining at ZPMCs machine shop. Mr. Liu stated that the outside facility worked directly for ZPMC and would be and would be performed the machining of all of the samples, except for the actual notches in the Charpy samples. Mr. Merrill agreed to tour the proposed facility and determine if further auditing would be required. Mr. Liu stated he would submit the machine shop procedures and would send Quality Control Inspector Ms. Zhou to track the components through the machine shop to ensure traceability. Mr. Merrill questioned and Mr. Liu confirmed that all testing of the samples would be done by ZPMC at the testing facility previously audited. ABFs Welding Engineer Mr. Craig Knops informed ZPMC that if there was any reason their plans or procedures changed, the such changes should be submitted before hand an allow adequate time for review.

Item	Description	WBS	Dwg No.	Status
1	Jim Merrill toured the new proposed machine shop (Shan Xun Machine Co.) and, following the suggestion from ABF Craig Knops, agreed to witness the entire cutting and machining process of all the mechanical specimens of a sample PQR in lieu of a complete audit. See photos of facility below.			



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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClary,David
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Quality Assurance Inspector

Reviewed By:	Lowry,Patrick
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QA Reviewer
